

ASAP

Split

Date: Tuesday, 04/11/2008 10:29:37 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 43184 -2		
Estimate Number	: 12967		
P.O. Number	:	Part Number	: D36373
This Issue	: 04/11/2008 S.O. No. :	Drawing Number	: D3637 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: B
Previous Run	: 42823	Material	:
Written By	: <u>W</u>	Due Date	: 11/11/2008
Checked & Approved By	:	Qty:	36 24 Um: Each
Comment	Est Rev:A New Issue 07-07-20 JLM Verified By:EC Est Rev:B change to REV.B as per dwg 08-02-11 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.1407 sf(s)/Unit Total : 3.3768 sf(s)
 2024-T3 .050 sheet
 Batch: 107711 IB 8-11-4

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3637
 Dwg Rev: B
 Prog Rev: B

IB 8-11-4

(40)

2-Deburr if necessary IB 8-11-4

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-11-4

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

806/4/04 counter (40)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Form as per Dwg D3637

SB 08/11/05

PTO

(32)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3637-3 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: AA Date: 08.11.18
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>43184</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08.11.04</u>	<u>5</u>	<u>RO.18 was crackings on previous w/o 42823</u>	<u>RA</u> <u>08.11.04</u> <u>ASJ 042</u>	<u>change to RO.18</u> <u>- NO MORE CRACKING</u> <u>PRESENT</u>	<u>RA</u> <u>08.10.04</u>	<u>S</u> <u>osclub</u>	<u>RA</u> <u>08.11.04</u> <u>08.11.04</u>	<u>S</u> <u>osclub</u>

NOTE: Date & initial all entries

Date: Tuesday, 04/11/2008 10:29:37 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 43184

Part Number: D36373

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 06/11/14 (32) counter

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- drill holes as per dwg using DT8979
- 2- c/sink holes as per dwg
- 3-deburr

08/08/11/06 (32)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.11.04

ENG'G APPROVAL

S 06/11/14 (32) counter

9.0

HAND FINISHING 1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

F2 08/11/14

(32)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-2 08/11/14

(32x)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 261

8/11/14

(32x)

SD

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/17

Job Completion



W 08.11.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

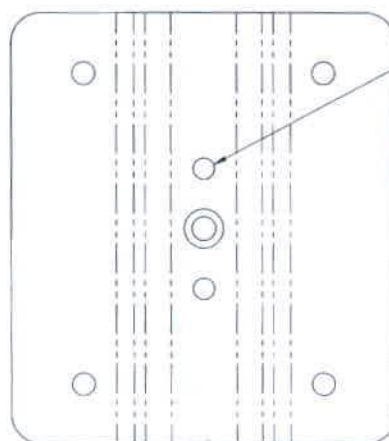
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

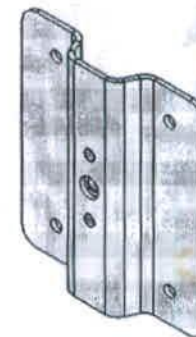


MS21059L4 NUT PLATE



MS20426AD3-3 RIVET
(2 PLACES)

D3637-1 BRACKET



D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

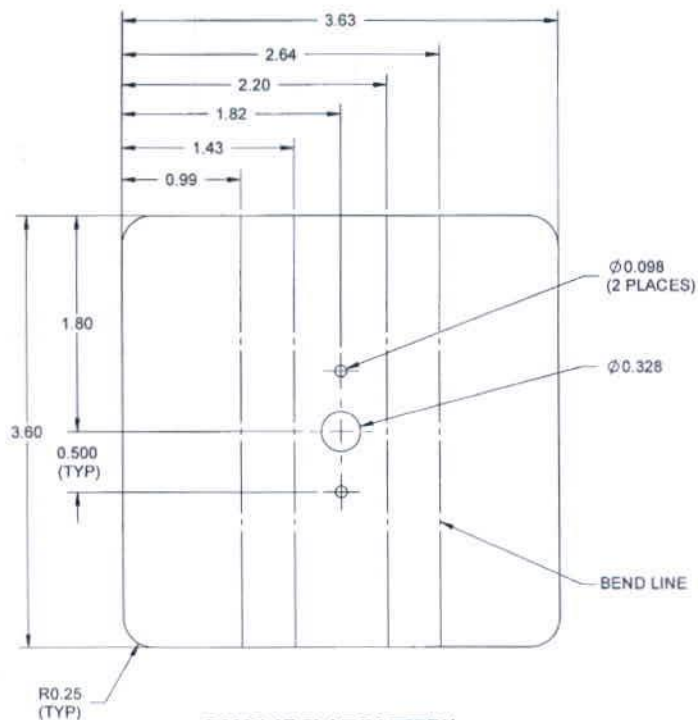
Handwritten signature/initials

B	FOR D3637-1, 1.15 WAS 1.30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
REV	DESCRIPTION	BY	DATE
DESIGN	IS		
DRAWN	LE		
CHECKED	PE		
MFG. APPR.	EP		
APPROVED	JP		
DE APPR.			
DATE	07.12.18		

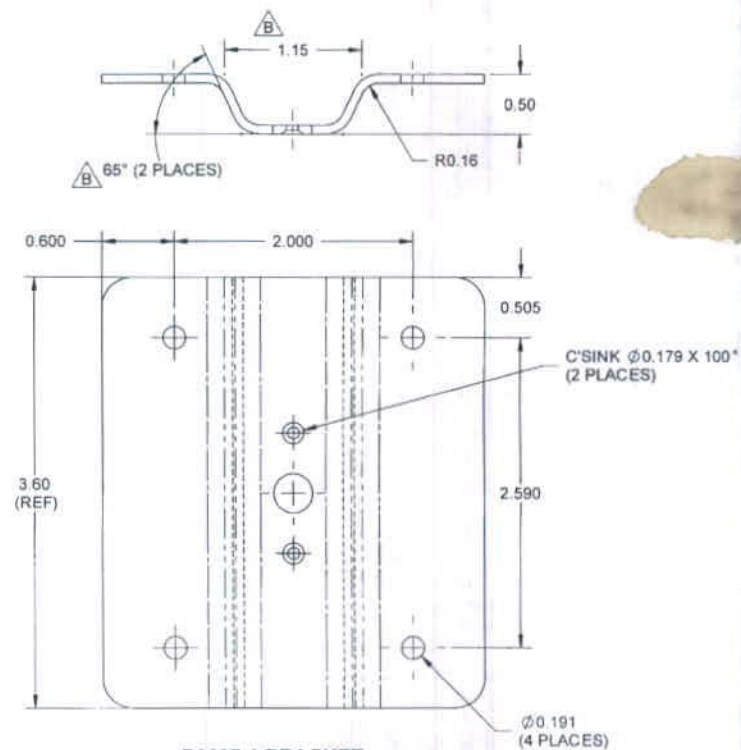
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3637** REV. B
TITLE **BRACKET** SCALE 1:1
SHEET 1 OF 3

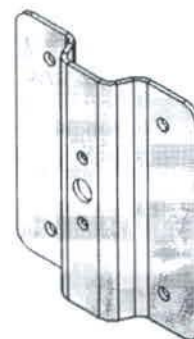
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D3637-1F FLAT PATTERN



**D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)**



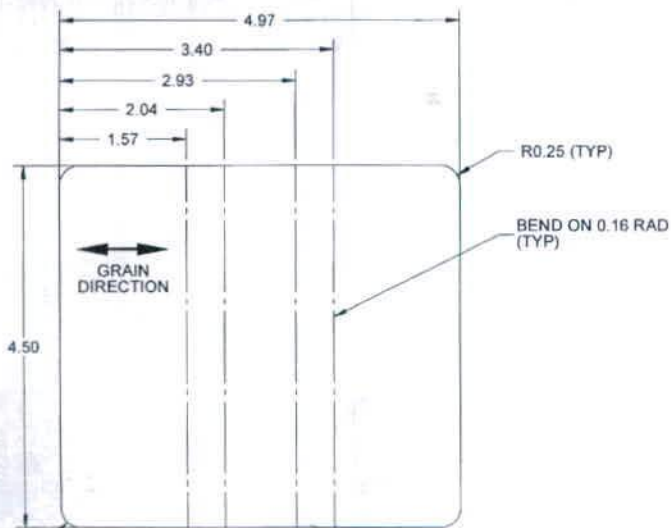
D3637-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

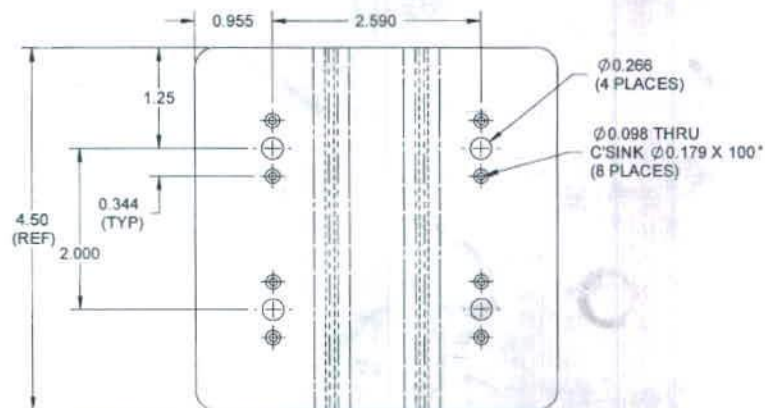
Uo 43184

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	NE	DRAWING NO.	REV. B
MFG. APPR.	CO	D3637	SHEET 2 OF 3
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BRACKET	1:1
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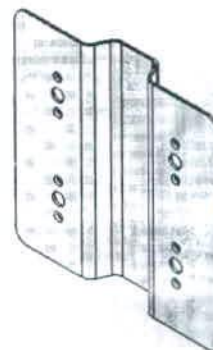
RELEASED



D3637-3F FLAT PATTERN



**D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)**



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG APPR	CD	D3637	SHEET 3 OF 3
APPROVED	MT	TITLE	SCALE
DE APPR		BRACKET	2:3
DATE	07.12.18	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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1.910
955
955
1.910

1.910
2.590
4.500

DART AEROSPACE LTD		Work Order:	43184
Description: BRACKET		Part Number:	D3637-3
Inspection Dwg: D3637-2 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article

x	Prototype
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[illegible]

Measured by:	HB
Date:	8-11-4

Audited by:	S. Subor
Date:	24/04

Prototype Approval:	<i>h</i>
Date:	<i>A</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

